

Date: Monday, 12/01/2009 2:36:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SET-SCREW
Job Number : 44644	
Estimate Number : 12490	
P.O. Number :	Part Number : D35331
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D3533 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 41606	Material :
Written By :	Due Date : 30/01/2009 Qty: 100 Um: Each
Checked & Approved By : JUD 09.01.13	
Comment : Est Rev:A New Issue 06-07-25 JLM verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 7969
 Purchase Part Number: 92311A564
 Supplier: MAC MASTER CARR
 Certificate of conformity is required

0209/01/14
 100

2.0	92311A564	Set Screw
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Set Screw

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

29/01/14 (100)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

502/01/19 (X100)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and stock
 Location: ST 108

88 09/01/20 (X100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SET-SCREW

Job Number: 44644

Part Number: D35331

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/21 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 010620

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

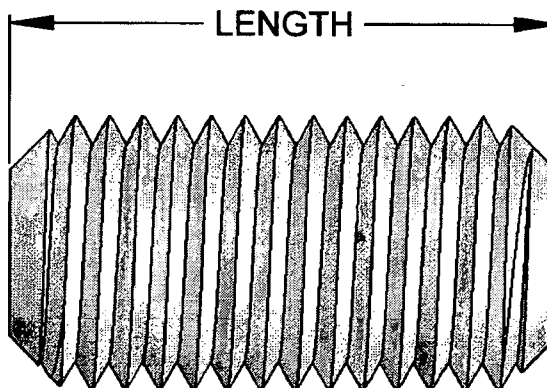
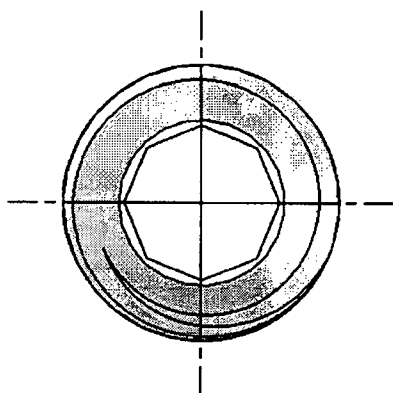
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3533	REV. B SHEET 1 OF 1
DATE 07.06.14		TITLE SET SCREW	SCALE NTS
REV	DATE	DESCRIPTION	
A	06.07.12	NEW ISSUE	
B	07.06.14	ADD D3533-3; ADD MATERIAL/FINISH COLUMN	

SPECIFICATION CONTROL DRAWING

RELEASED
07.08.03



B

PART NUMBER	MATERIAL AND FINISH	SIZE	LENGTH	POSSIBLE SUPPLIER
D3533-1	18-8 STAINLESS STEEL	1/4-28 UNF	1.000	McMASTER-CARR, P/N 92311A564
D3533-3	BLACK OXIDE ALLOY STEEL	#6-40 UNF	0.188	McMASTER-CARR, P/N 91375A161

B

NOTES:

- 1) TYPE: CUP POINT HEX HEAD SET SCREWS
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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Purchase Order
PO00007969

Page 1 of 2

200 Aurora Industrial Pkwy
Aurora, OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

McMaster-Carr Number
2321700-01

01/15/2009

Line	Description	Ordered	Shipped		LNS A11
1	92311A564 Type 18-8 Stainless Steel Cup Point Socket Set Screw, 1/4"-28 Thread, 1" Length, Packs of 50	2 Packs	2	2 - 699 - 04, 06 - 67 A564 2PK	1
2	95606A170 Nylon 6/6 Small-OD Flat Washer, 7/16" Screw Size, 1/2" ID, 11/16" OD, .028"-.034" Thickness, Packs of 100	1 Pack	1	2 - 623	2
3	6605K51 Hook and Loop Cable Tie, Black Flame-Retardant Wrap Around 6" Length, 1" Width, Packs of 10	1 Pack	1	3 - 119	3
4	8509A12 Removable Drill Bushing for Thin Gauge Material, 30 (.1285") ID, 3/8" OD, 3/8"-24 Thread Size	60 Each	✓ 60	2 - 494	4
5	8509A31 Lock Ring, 1/2" OD, for 8509a11-15, A41-43, Removable Drill Bushing for Thin Gauge Material	60 Each	✓ 60	2 - 495	5
6	8491A087 Steel Press-Fit Drill Bushing/Liner, 0.191" (11) ID, 5/16" OD, 1/2" Length	10 Each	10	2 - 495	6
7	8491A071 Steel Press-Fit Drill Bushing/Liner, 0.098" (40) ID, 1/4" OD, 1/2" Length	8 Each	✓ 8	2 - 494	7

Dart Aerospace Ltd

Assembly
Area

11

Cycle

11

Shelf

118

EXP

Documents

4

SS-R-0707

3 lbs
9 lines

FW1WBP24
01/15/2009
07:00/07:42
023

9001527185210

